

Date: Tuesday, 4/17/2007 11:05:02 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 31832		
Estimate Number	: 10345		
P.O. Number	: N/A	Part Number	: D28571
This Issue	: 4/17/2007 S.O. No. : N/A	Drawing Number	: D2857 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 30885	Material	: N/A
Written By	:	Due Date	: 5/10/2007 Qty: 24 Um: Each
Checked & Approved By	:		
Comment	: Est C 00.06.22 Removed P/O for powder coat EC Est D 06.05.01 Added level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)
Material: 2.00" X 1.25"
6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
(M6061T6B200001250)
Batch M100451

ML 07/06/11 25

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks 5.2"

ML 07/06/11 25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2857-1

ML/J.F. 07/06/12 24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

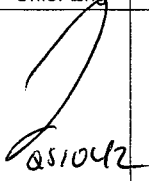
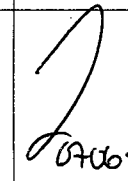
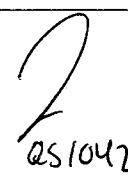
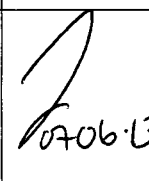


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML/J.F. 07/06/12 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/13	3	1 piece is scrap because the angle is not machined properly. R.C. Ø AXIS was not verified in the morning, before operating & operator error.	 05/04/12	Scrap: des tray, No Replace.	J.F. 07/06/13	 07/06/13	 05/04/12	 07/06/13

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:05:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 31832

Part Number: D28571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/06/13 24

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

MS 07/06/13 24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

MS 07-06-13 24

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS 07-06-13 24

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

MS 07-06-13 24

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS 07/06/14 24X

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 53

MS 07/06/14 24

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MS 07/06/14 24

Job Completion



MS 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31832
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857	Rev: <u>ATB</u>	Page 1 of 1	

LE 07.04.17

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310"	✓			
0.340	+/-0.010	0.340	—			
1.110	+/-0.005	1.109	—			
1.790	+/-0.010	1.793	—			
1.320	+/-0.005	1.319	—			
2.000	+/-0.010	2.000	—			
Ø0.171	+0.005/-0.000	Ø0.174	—			
0.340	±0.010	0.340	—			
0.147	+/-0.010	0.148"	✓			
0.376	+/-0.010	0.377"	✓			
0.126	+/-0.010	0.122"	✓			
0.063	+/-0.010	0.061	—			
4.000	±0.010	4.010"	✓			
Ø0.166	+0.005/-0.000	Ø0.166"	✓			
0.911	+/-0.010	0.915"	—			
0.600	+/-0.010	0.604"	✓			
0.447	±0.010	0.446"	✓			
0.125	+/-0.010	0.125"	✓			
0.150	+/-0.010	0.146"	✓			
Ø0.400	±0.010	0.393	—			

LE
07.04.17

LE
07.04.17

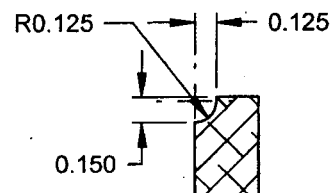
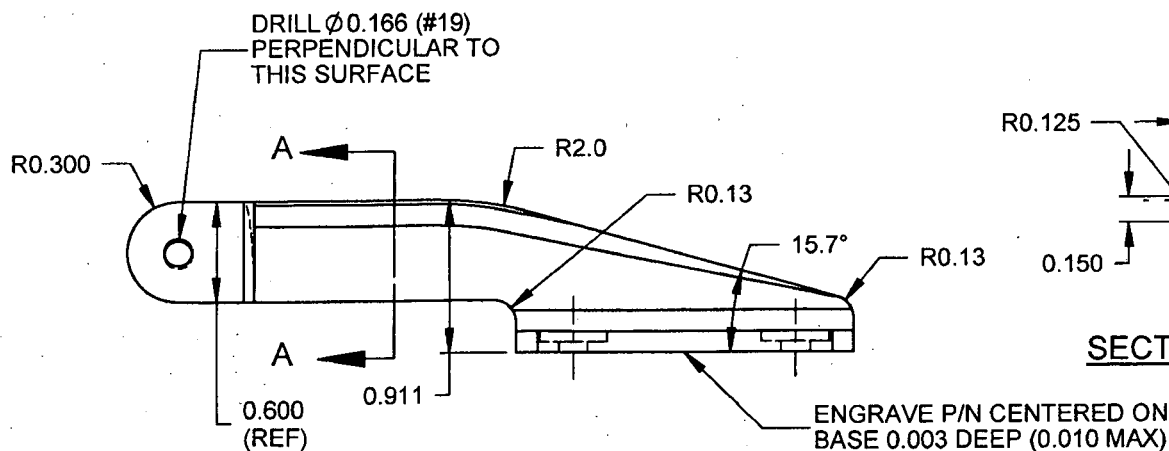
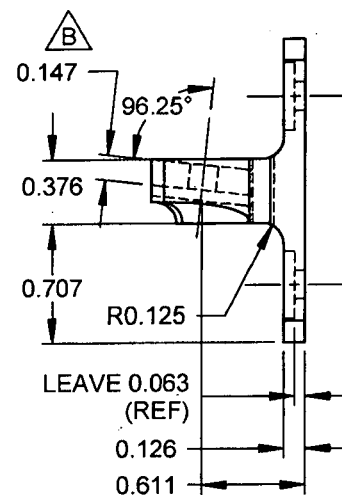
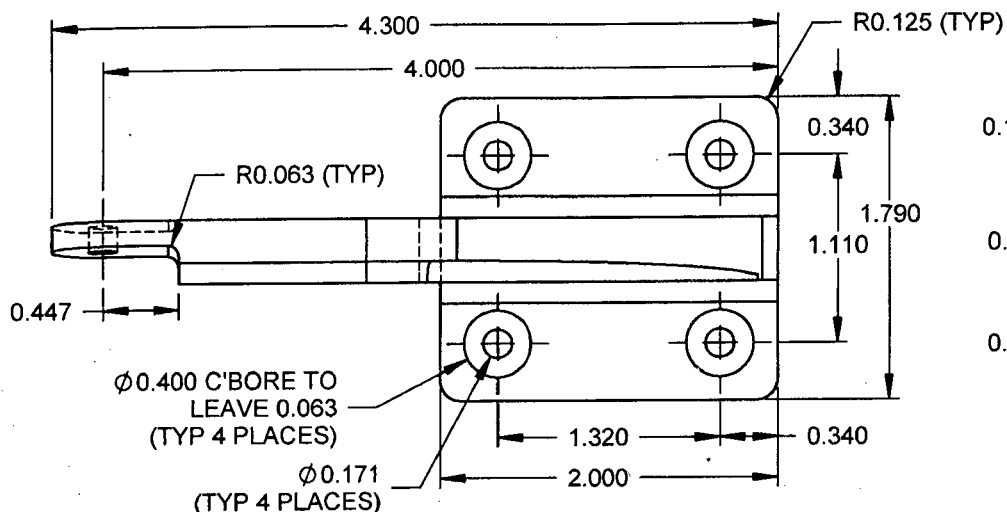
LE
07.04.17

Measured by: <u>MR/J.F.</u>	Audited by: <u>SEP</u>	Prototype Approval:	N/A
Date: <u>07/06/17</u>	Date: <u>07/06/17</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<u>[Signature]</u>

DART

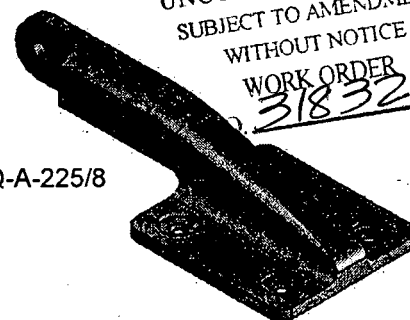
DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET SCALE 1:1		
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06-10-13**SECTION A-A**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31832

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

**COPYRIGHT © 1998 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

